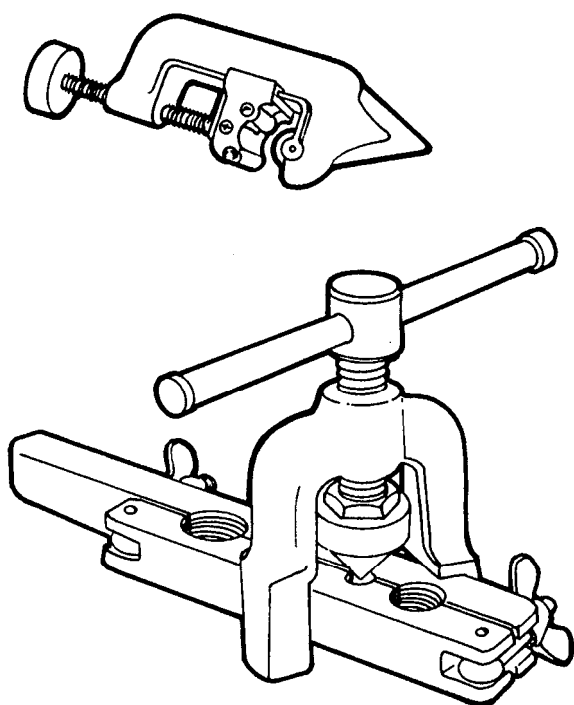


Chapter 36 TUBE CUTTING AND FLARING TOOLS

HOW TO CHOOSE AND USE THEM

The "Types and Uses" section provides you with a description of the tube cutting and flaring tool. These pages should help you select the right flaring combination to do the job.

The "Using" section tells you how to use the tube cutting and flaring tools to perform the desired function. The "Care" procedures tell you how to care for the items.

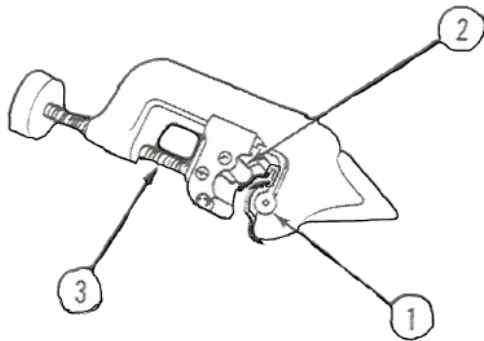


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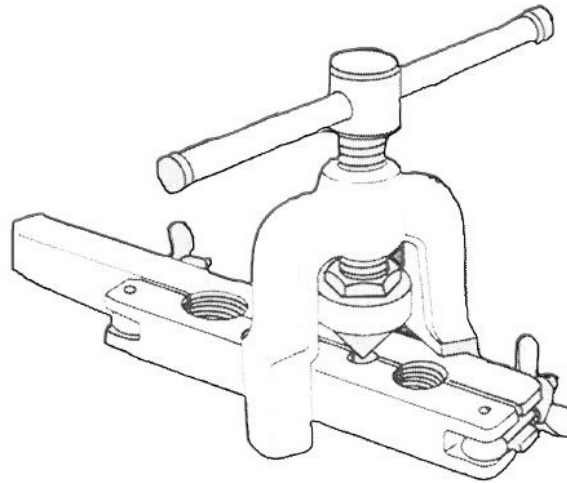
TYPES AND USES

TUBE CUTTERS



Tube cutters have a cutting blade (1), guide rollers (2), and an adjusting screw (3). Some cutters have a reaming blade attached to the frame of the cutter. Tube cutters can cut from 1/8 inch through 2-5/8 inches tubing. They can cut copper, aluminum, or brass tubing.

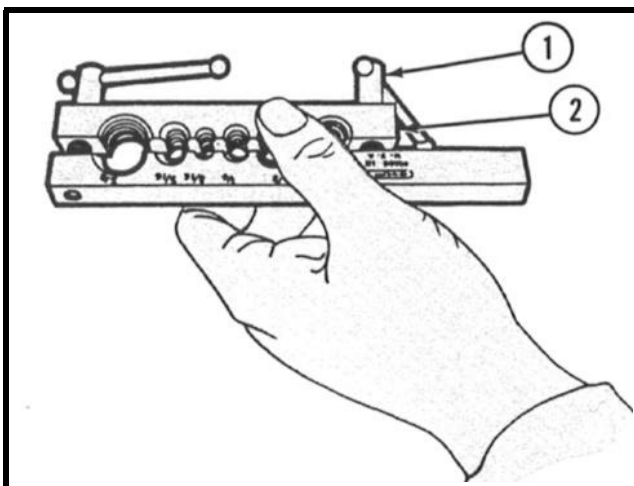
FLARING TOOL



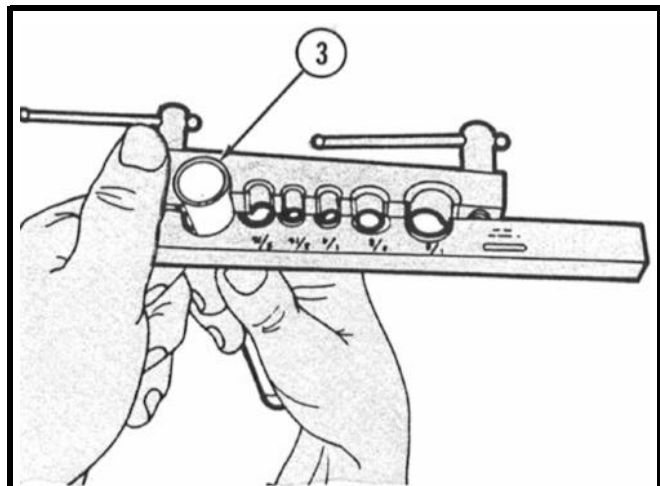
Flaring tools are of two basic types, single and double. They are used to put flares in soft tubing. The single flaring tool consists of a split die block, a locking clamp with compressor screw and a cone which forms a 45 degree flare on the end of the tube. The screw has a T-handle. The die block is constructed to be used on the following outside diameter tubing: 1/8, 3/16, 1/4, 5/16, 3/8, 7/16, 1/2, 5/8, and 3/4 inch.

The double flaring tool consists of a split die block, a locking clamp with compressor screw, adapters for turning tube edge, and a cone which forms a 45 degree flare on the end of the tube. The screw has a T-handle.

USING A FLARING TOOL

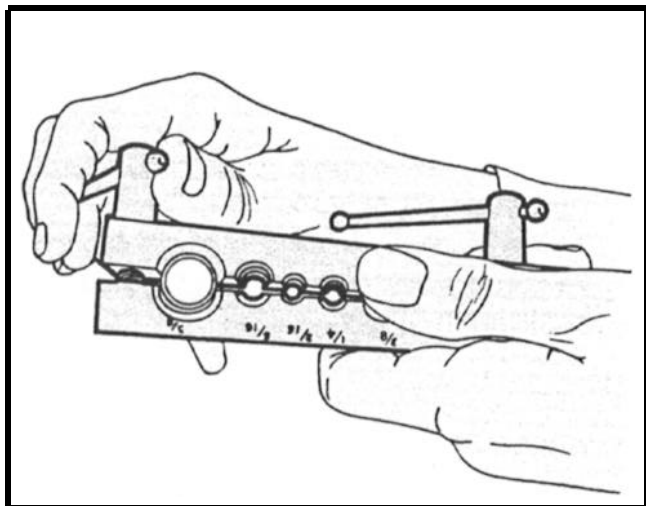


- 1 Loosen die block clamp screws (1), and open die block clamp (2).



- 2 Insert tubing to be flared (3) into die block clamp.

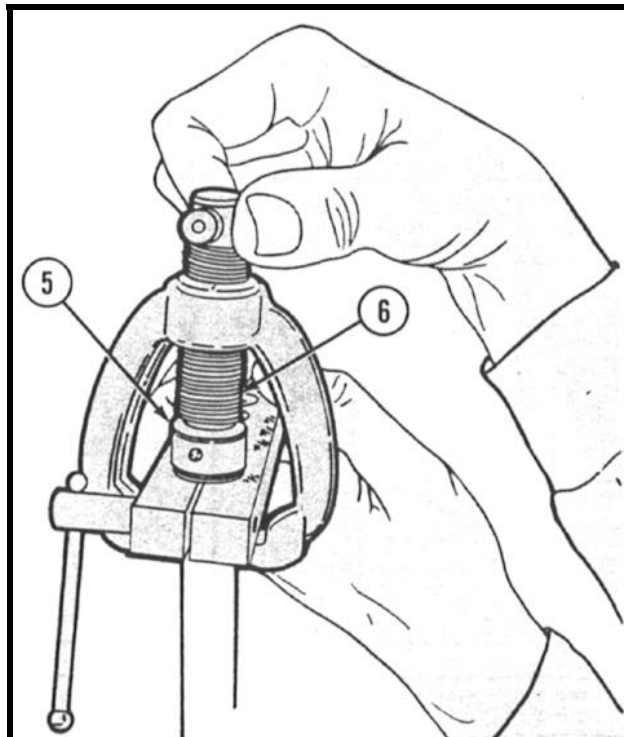
USING A FLARING TOOL - Continued



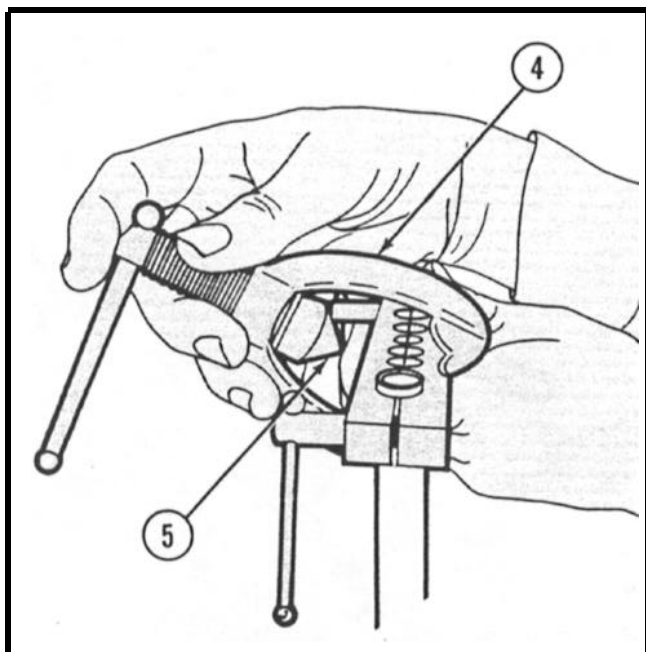
- 3** Hold tubing so there is about 1/8 inch extending above die block clamp, and tighten die block clamp screws.

NOTE

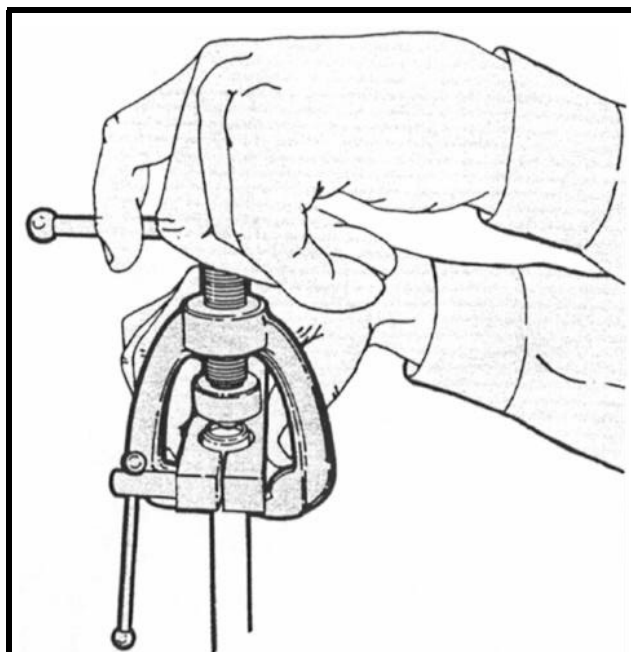
Do not over-tighten cutter as tubing may kink and flatten.



- 5** Tighten feed screw (6) forcing the tip (5) into the tubing and forcing the tubing into the chamber of the die block clamp.

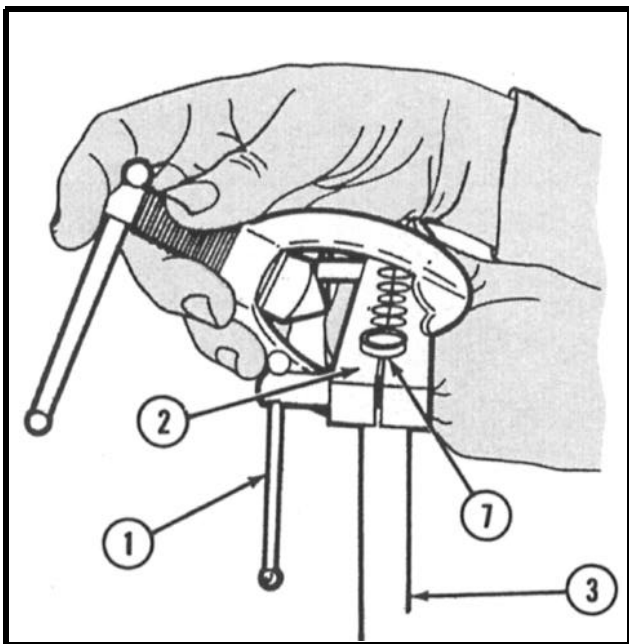


- 4** Slide yoke (4) over die block clamp, and align the tip (5) over the end of tubing.



- 6** When desired flare is reached, unscrew feed screw, and remove yoke from die block clamp.

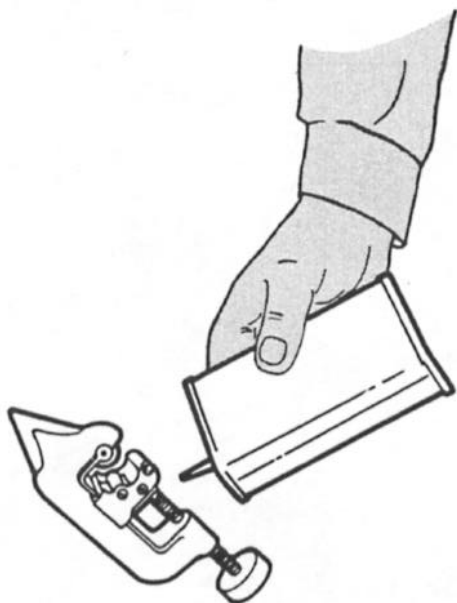
USING A FLARING TOOL - Continued



- 7 Unscrew die block clamp screws (1) and open die block clamp (2), releasing tubing (3).
- 8 Inspect flange (7) in tubing for cracks or breaks.
- 9 If a crack or break is detected, the tubing will have to be cut and reflanged.

CARE OF TUBE CUTTERS AND FLARING TOOLS.

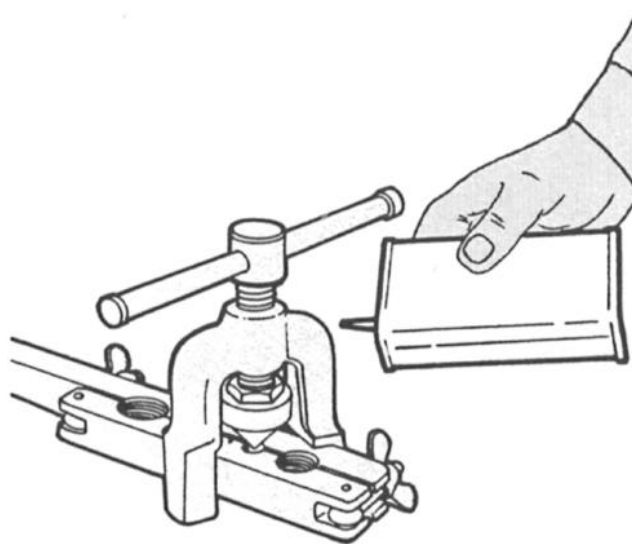
TUBE CUTTERS



Keep cutting wheel clean and lightly oiled. If a reaming device is mounted on- the body of the cutter, keep it retracted when not in use.

Store tube cutters on a rack or in a box.

FLARING TOOL



Keep surfaces clean and lightly oiled. Close single flaring tools and tighten cone into block for storing. Keep double flaring tools in the case when not in use.